

# Work Order ID 81598

**\*81598\***

March-16-12 8:35:04 AM

Page 1

Item ID: D3315-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 15/03/2012 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/16 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3315	Rev B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

1010 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 81598

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Page 2

March-16-12 8:35:04 AM

Item ID: D3315-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate

Stop **\*NS2\***

Start Date: 15/03/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00							
Small Fab	Memo Debur if necessary <i>N/A</i>	0.00							
140 <b>*140*</b> Brake NC	NC-BRAKE	0.00							
Brake NC	Memo 1- Form using DT8751 Die as per Dwg D3315Rev: <i>B</i> 2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: <i>B</i>	0.00							<i>8/12/06/29</i>
150 <b>*150*</b> QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							<i>7</i>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81598

**\*81598\***

Page 3

March-16-12 8:35:04 AM

Item ID: D3315-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate  
 Start Date: 15/03/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 29/03/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:								
	B Qty Part Number Description Batch A/R								
	N/A 7560 Hardcoat Rod m/22359								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

⑩ me 12-08-15

DAS 16 12/8/15

DMB 12-8-15

DAS 16 12/8/15

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*81598\***

Page 4

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 15/03/2012    **Start Qty:** 5.00    **\*5\***

**Cust Item ID:**

**Required Date:** 29/03/2012      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*190\*

## Memo

START TIME:

OVEN TEMPERATURE:

## Powder Coating

200

### QC3- Inspect Part Finish

0,00

**\*200\***

QC

## Memo

0.00

## Quality Control

210

### Packaging

0.00

**\*210\***

### Packaging

## Memo

0.00

## Packaging

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-1, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location: 560

W/O:		WORK ORDER CHANGES					
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**Work Order ID 81598****\*81598\***

Page 5

March-16-12 8:35:04 AM

Item ID: D3315-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearplate

Start Date: 15/03/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

ML 12/08/23

U1208,24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81598
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3315-1
<b>Inspection Dwg:</b> D3315	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	0.271 x 0.460	✓		✓	mmol
4.402	+/-0.010	4.401"	✓		✓	"
4.137	+/-0.010	4.129"	✓		✓	"
3.550	+/-0.010	3.558"	✓		✓	"
5.464	+/-0.010	5.461"	✓		✓	"
5.214	+/-0.010	5.206"	✓		✓	"
1.224	+/-0.010	1.221"	✓		✓	"
2.57	+/-0.030	2.583"	✓		✓	"
6.273	+/-0.010	6.271"	✓		✓	"
8.224	+/-0.010	8.220"	✓		✓	Prod Joz
9.515	+/-0.010	9.515"	✓		✓	"
11.429	+/-0.010	11.424"	✓		MT	"
15.474	+/-0.010	15.474"	✓		MT	PB01
16.379	+/-0.010	16.379"	✓		MT	"
21.360	+/-0.010	21.360"	✓		MT	"
23.474	+/-0.010	23.474"	✓		MT	"
26.273	+/-0.010	26.273"	✓		MT	"
29.42	+/-0.030	29.42"	✓		MT	"
0.060	+/-0.010	0.058"	✓		✓	mmol
Ø0.300	+0.006/-0.001	0.303"	✓		✓	"

<b>Measured by:</b>	TM
<b>Date:</b>	12-6-24

<b>Audited by:</b>	MA
<b>Date:</b>	12-06-25

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	MA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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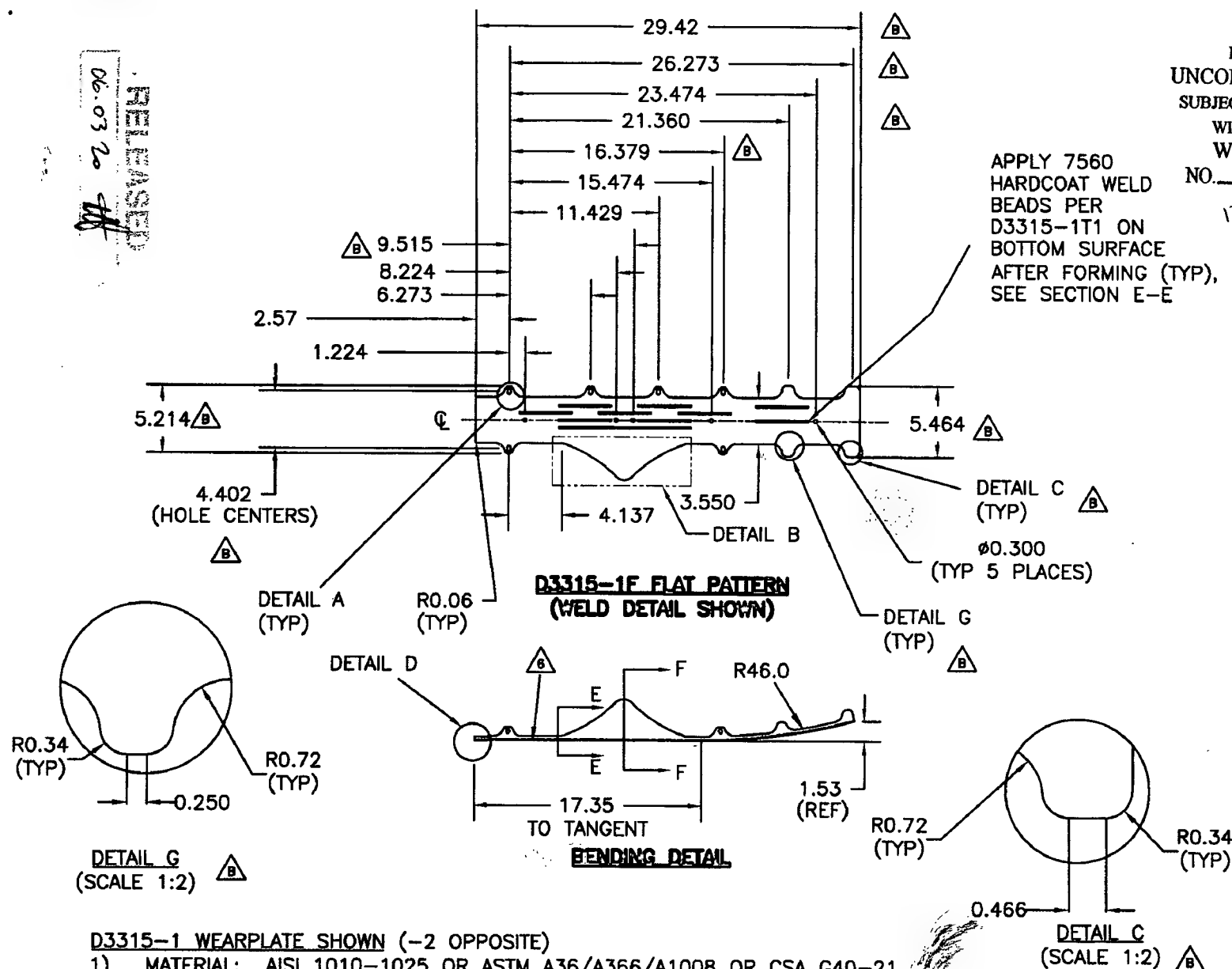
RELEASED  
06.03.20

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 01598 MCT

12/03/16

**DART**

APPLY 7560  
HARDCOAT WELD  
BEADS PER  
D3315-1T1 ON  
BOTTOM SURFACE  
AFTER FORMING (TYP),  
SEE SECTION E-E



**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
11	11	D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	NEW ISSUE	REV. B
04.09.10	NEW ISSUE	SHEET 1 OF 4
B	UPDATE DIMENSIONS	SCALE
06.01.31	UPDATE DIMENSIONS	1:12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

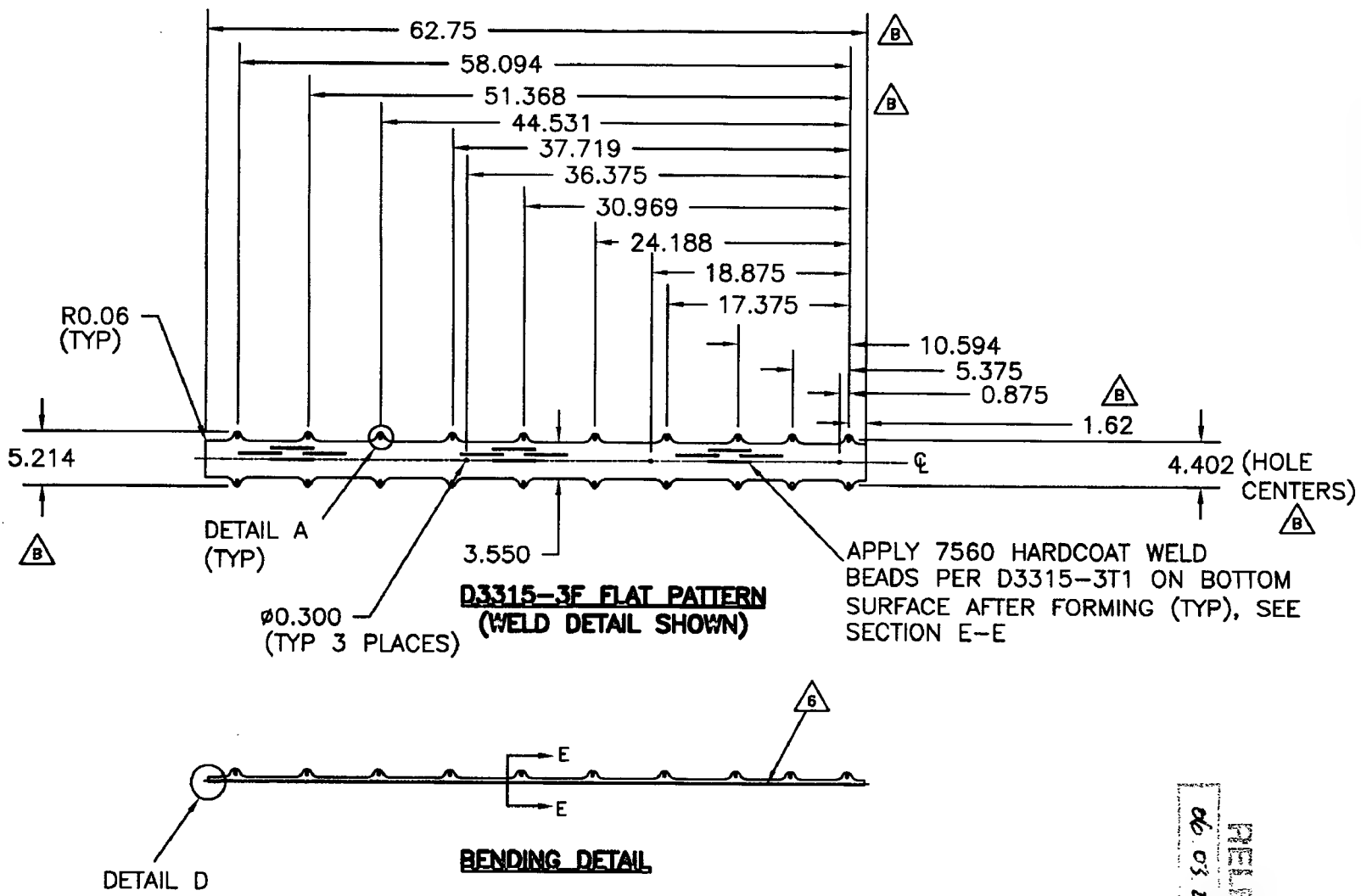
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81598



**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
06 03 20

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 4
		SCALE	1:16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

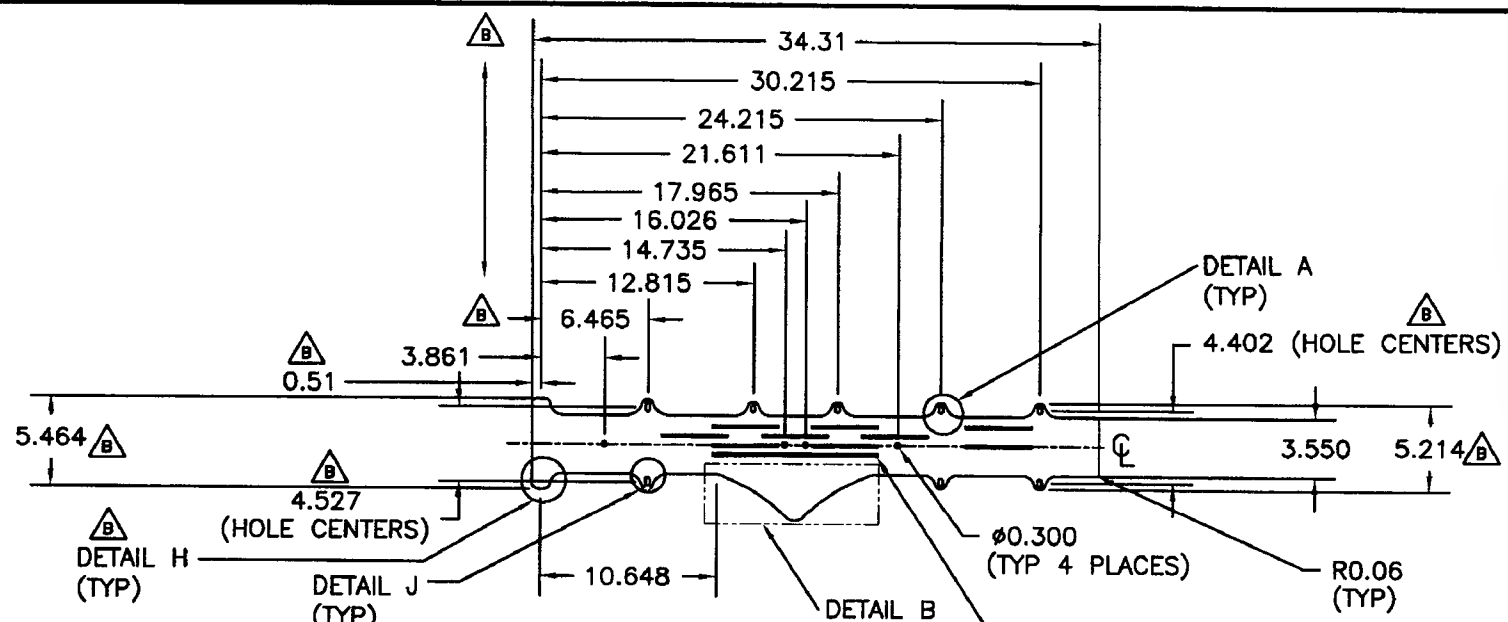
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

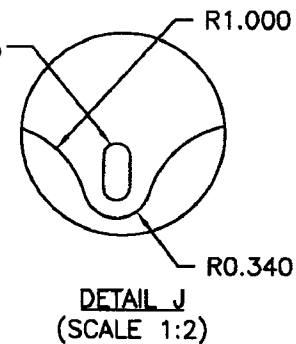
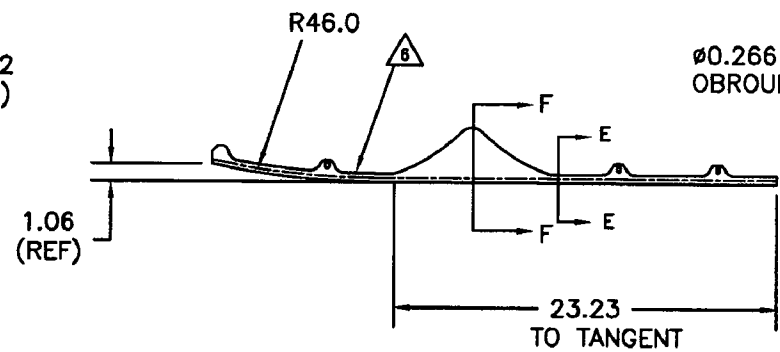
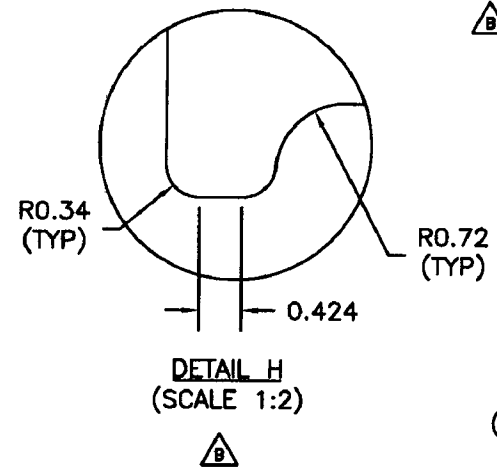


81598



**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSION ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	814	DRAWN BY	814	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 3 OF 4
				SCALE 1:12

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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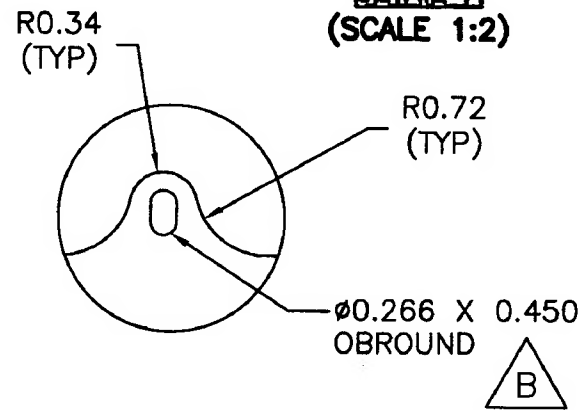
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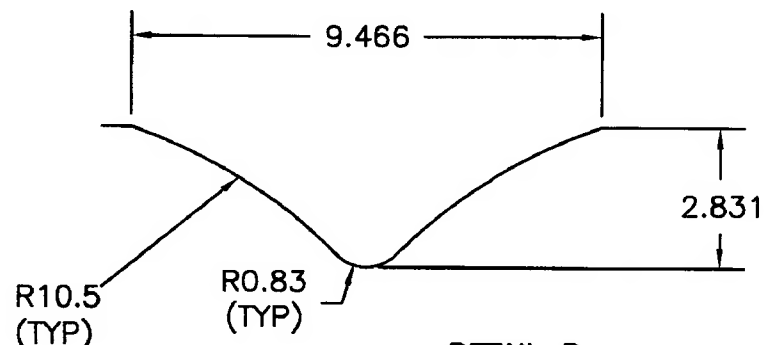
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DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 4 OF 4
		SCALE	NTS	

81598

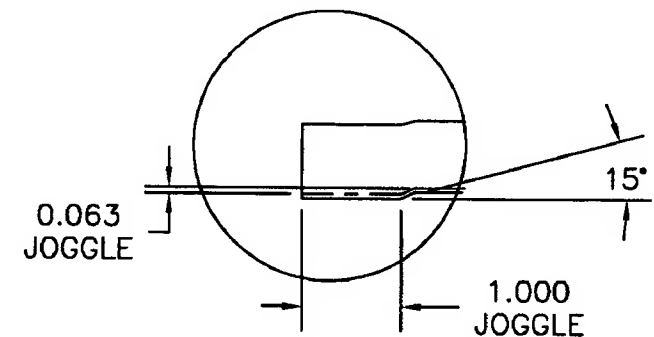
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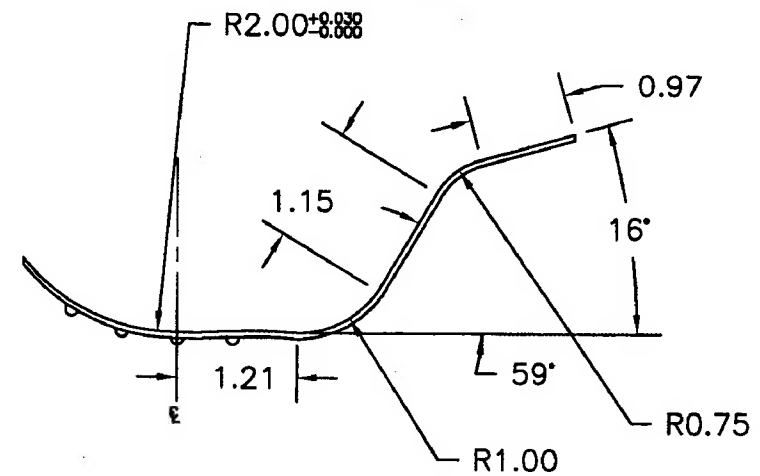
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(SCALE 1:4)



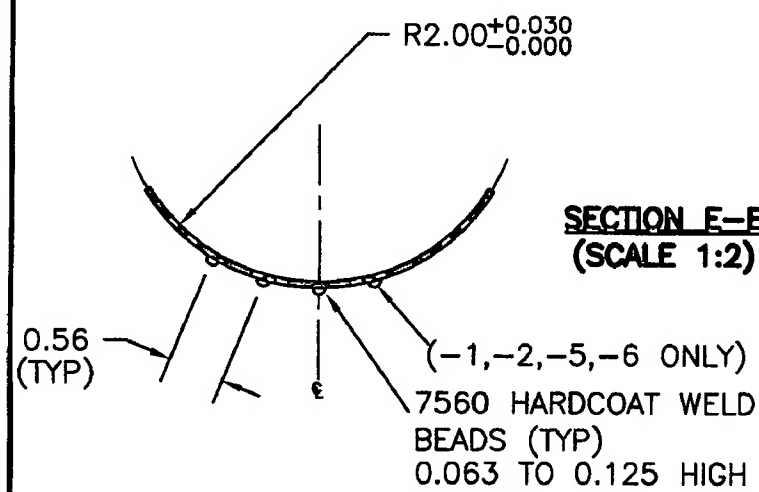
**DETAIL D**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)



**SECTION E-E**  
(SCALE 1:2)



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06.03.20

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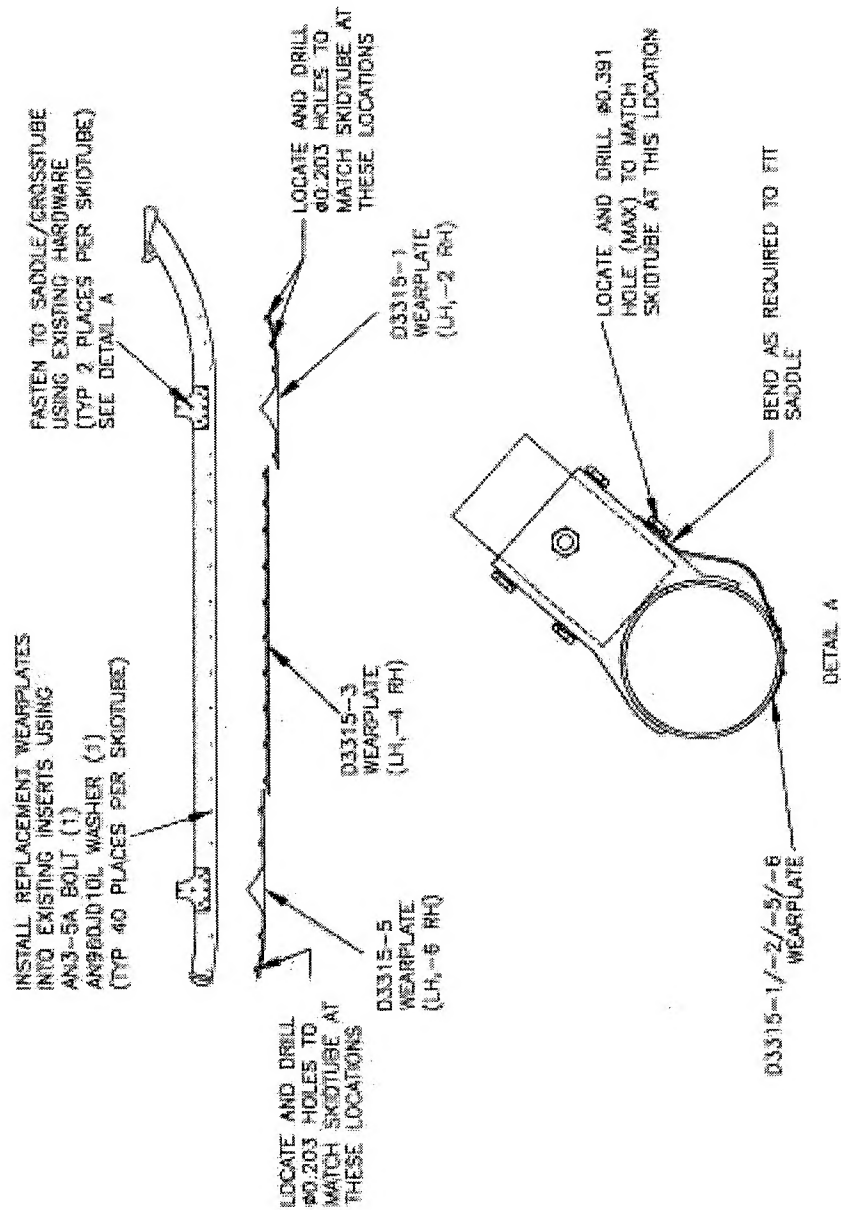
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**NOTE:** Date & initial all entries

FIGURE 1: D412-726-111 WEARPLATE\_ML  
(205/212/412 STANDARD SKIDTUBE)  
(LH SKIDTUBE SHOWN, VIEW LOOKING OUTBOARD)  
(RH OPPOSITE)



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